Work Order ID 56241

Wednesday, February 17, 2010 10:07:02 AM



Page 1

Item ID:

D412-724-041

Revision ID:

Head Rest Assembly, Center Item Name:

Start Date:

2/18/2010

QC:

Start Qty: 4.00 Required Date: 3/3/2010

Req'd Qty: 4.00

Accept



Setup

Start



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date:

Date: 10-2-17 Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**

Draw Number Draw Plan Rev.

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr Rev N/A

N/A 100

DC

Document Control

DOCUMENT CONTROL

Memo

Memo

0.00

0.00

0.00

0.00

Memo
If D412-724-041 is a W/O on it's own, □Photocopy bluefile and create labels per
\(\lambda \) (0 \(\lambda \) \(\lambda \) \(\lambda \) PPP D412-724-041 CHG001

110

Packaging Packaging

Pick Kit

10-3-5 50

120

OC4-100% Inspect kits for completeness

Memo

0.00

0.00

Quality Control

Dart Aerosp	pace Ltd
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W/O:			W	ORK ORDER CHANG	ES			<u> </u>	***
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									1
Part No		PAR #: esolution:							
NCR:				DER NON-CONFORM				Date:	
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		ion B	Verification Section C		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector
									N set
							-		-

Work Order ID 56241

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Page 2

Item ID:

D412-724-041

Accept

Setup Start



Revision ID:

Item Name:

Head Rest Assembly, Center

Start Date:

2/18/2010

Start Qty: 4.00

Required Date: 3/3/2010

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Reject

Qty

Stop



QC:

Operation

Set Up/ **Run Hours** Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Number Insp. Stamp

130

Sequence ID/

Work Center ID

Packaging

Packaging

Description

Packaging

0.00

0.00

Memo Identify and pack for shipping as per PPP D412,724-DPPP Rev: 041 Location:

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mr-10-3-17

Dart	Aeros	pace	Ltd
			B

W/O:	100		W	ORK ORDER CHANG	GES			•
DATE	STEP	PRO	PROCEDURE CHANGE					Approval QC Inspector
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Part No		PAR #:						
Resolution:								
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DATE	STEP	Description of NC			ction B	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Wednesday, February 17, 2010 10:07:02 AM

Work Order ID: 56241

Parent Item: D412-724-041

Parent Item Name: Head Rest Assembly, Center

Start Date: 2/18/2010

Required Date: 3/3/2010

	PP Rev:A \(\text{104.09.0}		J/JLM						Start Oate: 2/18/ Start Oty: 4.00	2010	Required Date:	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R6 &		Purchased	No			120	Each	328.0000		10-3	Jec	
				Warehoo		Loc	<u>Otv</u>	Loc Code	16.1			
				Loca Main Wa								
				ST			328		5 E D		I.Tr.Sagara	
				_	101203 113524 113595		14 300 14		T	6		
D3303-041 **		Manufactured	No		K	120	Each	4.0000)-3	s sp	i sunt
V	1			Wareho Loca	use ation	Loc	Oty	Loc Code	1	3 563	97/01/19	13/12
				Main Wa	arehouse		4					

	D3304-041	10	
A			
11	Tube Assembly		

Manufactured No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3	
54379	3	
Main Warehouse		
ST187	20	
54438	20	

120

10-3.5.

3

Dart Aerospace L	_td
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W/O:			W	ORK ORDE	R CHANG	GES				
DATE	STEP	PROC	PROCEDURE CHANGE B							Approval QC Inspector
									- 10	
Part No		PAR #:								
	R	esolution:							Date: _	<u> </u>
NCR:	,	W	ORK ORD	ER NON-CO		ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng			tion B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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								*** s		(3)
									7	# E
		1 1 2								ř .

3.0 INSTALLATION PROCEDURE

REFERENCE ONLY

To install a Dart Head Rest Assembly:



- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -G41	QTY -043	QTY -044	Part Number	Description
X 2	X			D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
1	diction	X		D412-724-041 D412-724-043	Head Rest Assembly, Center Head Rest Assembly, LH
1	- CHIN	Di-	Х	D412-724-044	Head Rest Assembly, RH
,	1	-1	1	D3303-041	Head Rest
	frej de	1		D3304-041 D3304-043	Tube Assembly Tube Assembly
0,5200	Soft		1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw

Dart Aerospace Ltd					
W/O:					

W/O:			W	ORK ORDER CHANGE	S				
DATE STEP		PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				e					
							. Option		
Part No:		PAR #:	Fault Category:		NCR: Yes	NCR: Yes No DQA: Date:			
	Res	solution:	ition: Disposition:			osed:	Date: _	Date:	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR)	¥.		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Office Eng	Criter Eng	Date			7	
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Process Plan: MF

Operation

Description

Date: 10-2-17 Tooling:

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0.00

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Accept Qty

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Run

Setup Start

Stop

Start

Stop

Reject Number

Insp. Stamp

N/A 100

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Packaging

Pick Kit

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0.00

Packaging

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Quality Control

QC4-100% Inspect kits for completeness

Memo

0.00

0.00

V 10-3-11

REFERENCE ONLY

